Work Order ID 67698 Tuesday, March 29, 2011 1:01:30 PM									Page 1	=== I
Item ID: D3313-1 Revision ID: Item Name: Mounting Bracket Start Date: 3/29/2011 Start Ot	y: 6.00	Accept				S	Setup Sta	1 188111881 1		
Start Date: 3/29/2011 Start Qt Required Date: 4/1/2011 Req'd Q Reference:			Cust Item I Customer:	D:						
Approvals: Process Plan:	Date://-03-2	7 Tooling: SPC (Y/N):		ate:		R	tun Sta Sto			
Sequence ID/ Operation Work Center ID Description Draw Nbr Revision Nbr		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
100 Waterjet	Memo	0.00				HB 11-7	3- <i>3</i> 9			_
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: Prog Rev: 2-Deburr if necessary		<i>j</i> .						^	O ₁
110 QC2- Inspec	ct parts off machine FAI/FAIP	0.00				r&11	·-3-29	· ·		P

0.00

Memo

Quality Control

DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng/Prod Mgr QC Inspector

Part No: <u>03313-/</u>	PAR #: Fault	Category: Small Fab/W-Jef	NCR: Yes No	DQA:	Date:	1103-20
Resolution:	Dispo	sition:	QA: N/C Closed	l:	Date:	11/4/4

NCR: 67	698	W	ORK OR	Corrective Action Section B	E (NCR)	1		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
11 િઝીંક	# (10	Found that aly al Port has estro holes cut into uit From the w13. R.L. Port floates Durin water ofting (Ports have no tob within)	psiun	-Scrop + Destry aby x/ no replace extras were made.	\$ \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	Sulostro	losur	\(\sigma\)

Work Orde Tuesday, March											Page 2
Revision ID:	D3313-1 Mounting Brad	cket		Accept	111111111111111111111111111111111111111				Setup St	111	
	3/29/2011	Start Qty: 6.00 Req'd Qty: 6.00	!		Cust Item II Customer:	D:				· (i ii s ii s i i ss i
Approvals:	00	n:	Date:	Tooling: SPC (Y/N):	Da	te:				ton u	
Sequence ID/ Work Center ID 120 QC Quality Control	•	Operation Description QC8- Inspect parts - secon	d check	Set Up/ Run Hours 0.00 Suls 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reje Num	Insp. Stamp
130 Brake NC Brake NC		Bend as per dwg Memo		0.00 0.00	163/30			9		<u> </u>	

140 QC

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00 S do3/30

Dart Ae	rospace	Ltd							
W/O:			V	VORK ORDER CHAN	NGES				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No		PAR #:							
	Re	solution:	Disposit	tion:	QA: N/C	Closed:	.	Date: _	
NCR:			WORK OR	DER NON-CONFOR	MANCE (NO	R)			
DATE	STEP	Description of NC			Section B	Verific	ation	Approval	Approva
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign Da		on C	Chief Eng	QC Inspecto
	}			-					



Page 3

Item ID:

D3313-1

Accept

Setup Start

Stop



Revision ID: Item Name:

Mounting Bracket

Start Date: 3/29/2011 Required Date: 4/1/2011

Start Oty: 6.00

Req'd Otv: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

150

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Otv

Reject Qty

Reject Insp. Number Stamp

Memo

0.00

0.00

BL 11-3-31

160

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3,5.7) per OSI005 4.3

Memo

0.00

4 Bl 11-3-31.

170

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** DATE STEP PROCEDURE CHANGE Bv Qtv Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP** Sign & **Action Description** Initial Section A QC Inspector Section C Chief Eng Chief End Date Chief Ena

Chief Eng Chief Eng Date

NOTE: Date & initial all entries

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Work Order ID 67698

Tuesday, March 29, 2011 1:01:30 PM



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Item ID:

D3313-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Mounting Bracket

Start Date:

3/29/2011 Start Qty: 6.00

Required Date: 4/1/2011

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ **Work Center ID**

180

Packaging

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan

Accept

Reject

Insp.

Memo

Memo

0.00

Qty Code

Qty

Reject Number

Stamp

Packaging

190

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

0.00

0.00

MF 11-04-01

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval **Approval** By Qty DATE **STEP** PROCEDURE CHANGE Date Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B Description of NC Verification **Approval** Approval DATE | STEP | **Action Description** Sign & Initial Section C Chief Eng OC Inspector

	Section A	Chief Eng	Chief Eng	Date	Section C	Chief Eng	QC inspector
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NOTE: Date & initial all entries

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Picklist Print

Tuesday, March 29, 2011 1:01:37 PM

Work Order ID: 67698

Parent Item:

D3313-1

Parent Item Name:

Mounting Bracket



Start Date: 3/29/2011

Required Date: 4/1/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A 10.09.24 PER DWG REV.A DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063	 	Purchased	No			100	sf	63.0000	0.14	0.84	2.	70	
6061-T6 063 Sheet		II .									B11-3-2	9	

Location	Loc Oty	Loc Code	
MAT021	63		
113608	5		
116308	-38		116208)
116623	20		

Dart Ae	rospace	e Ltd									•
W/O:				W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE	СНА	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #:	Fault	Cate	gory:	_ NCF	: Yes	No DQ	\:	_ Date: _	
	R	esolution:	Dispo	sitio	n:	_ QA:	N/C Cld	sed:		Date:	
NCR:		1	WORK C	ORD	ER NON-CONFORMA	NCE	(NCR)			
DATE	STEP	Description of NC Section A	Initia	1	Corrective Action Section Action Description	on B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspecto
1		Collon	Chief E	ng	Chief Eng		Date			3	
											,

DART AEROSPACE LTD	Work Order:	41698
Description: Mounting Bracket	Part Number:	D3313-1
Inspection Dwg: D3313 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	1761,	×		V 1802	
0.87	+/-0.030	- 874	8		V	
4.45	+/-0.030	4.456	8		V	
0.45	+/-0.030	,487	8		V	
1.600	+/-0.010	1.601	×		V	
1.600	+/-0.010	1,600	7		V	
Ø2.00	+0.012/-0.001	2,000	>		J	
4.45	+/-0.030	4,448	≽		V	
0.87	+/-0.030	-874	٨		V	
0.30	+/-0.030	. 300	3-		ν	
0.56	+/-0.030	. 567	2		V	
1.00	+/-0.030	1.001	8		V	
2.00	+/-0.030	500.6	n		V	
3.12	+/-0.030	3,138	<i>A</i>		V .	
3.12	+/-0.030	3,175	7		V	
0.45	+/-0.030	451	?		V	
0.063	+/-0.010	ر <u>موا</u>	>-		V	
						· · · · · · · · · · · · · · · · · · ·
				_		
						· · · · · · · · · · · · · · · · · · ·

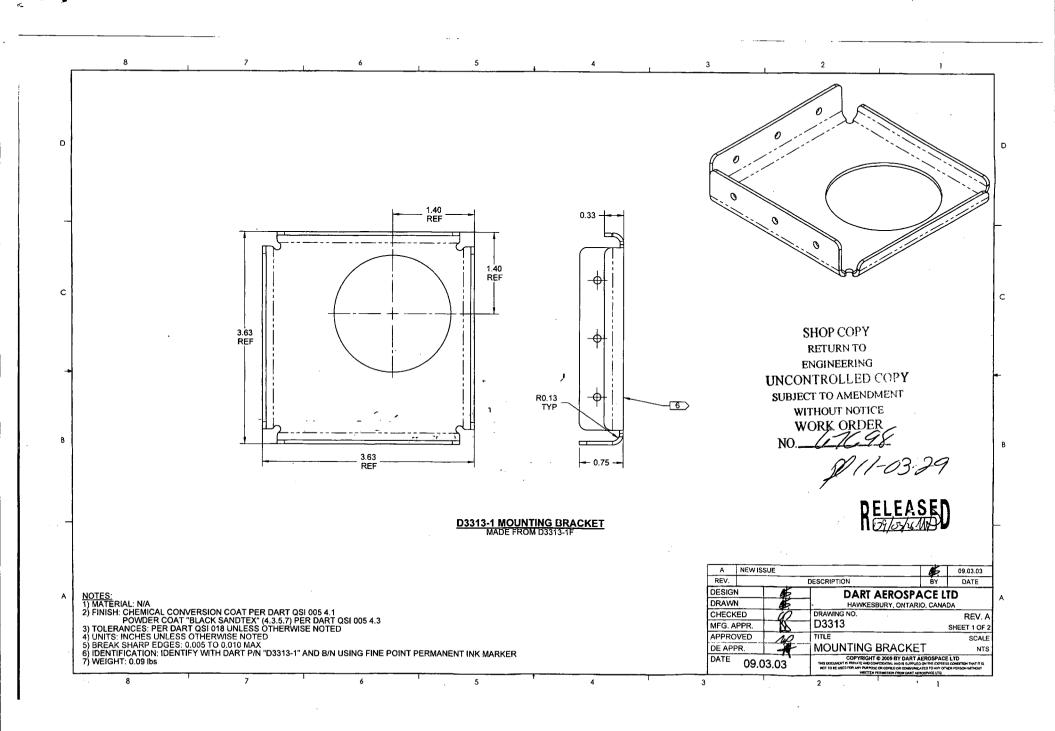
Measured by:	Audited by:	Preliminary Approval:
Date: 11-3-39	Date: 1103/30	Date:
	in the second of	

Rev	Date	Change	Revised by	Approved
Α	10.10.06	New Issue	KJ 🕏	1 11
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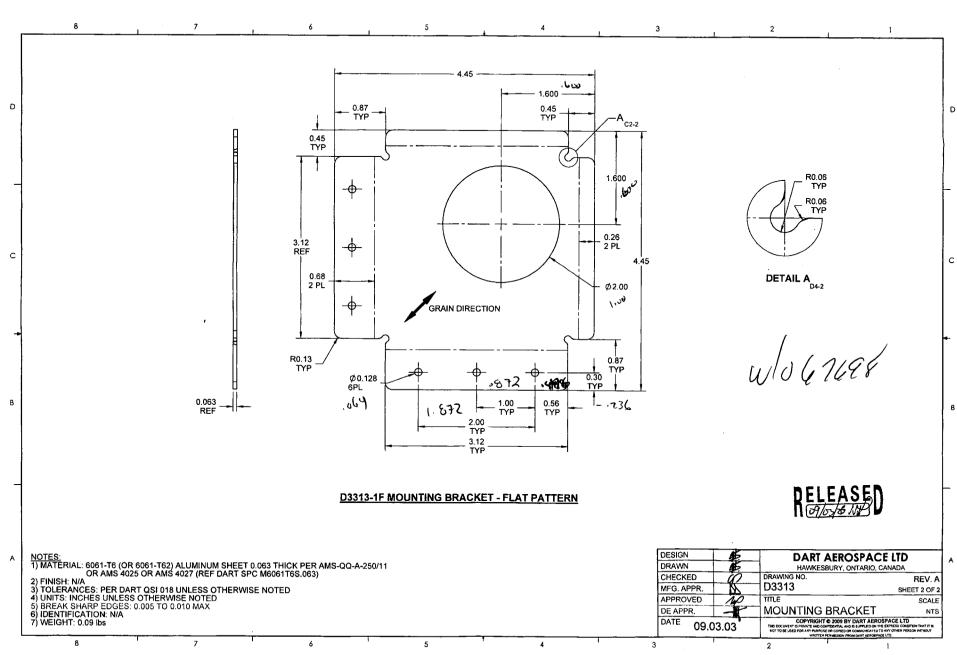
Dart Aerospa	ice Ltd
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W/O:		WORK ORDER CHANGES												
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
										- 10 - 10 - 10 - 10 - 10 - 10 - 10 - 10				
Part No: PAR #:														
		esolution:	Disposition		QA: N/C	Closed: _	sed: Date:							
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		Description of NC	Corrective Action		Sectio	Section B		ication	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Desci Chief Eng	iption	Sign Date	& Sec	ction C	Chief Eng	QC Inspector				
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W/O:				WC	RK ORDER CHANGI	ES					
DATE	STEP	STEP PRO		OCEDURE CHANGE			Ву	Date	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:		l l							
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	STEP			Corrective Action Section					Verification	Approval	Approval
DATE			Initial Chief En		Action Description Chief Eng		Sign & Date	l l	ion C	Chief Eng	QC Inspecto
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W/O:				WORK ORDER CH	ANGES					-
DATE	STEP	PRO	CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector		
Part No):	PAR #:	Fault	Category:	NC	R: Yes	No DQ	A :	Date: _	
	Res	solution:	Dispo	stion:	Q <i>A</i>	: N/C C	losed:		Date: _	
NCR:		,	WORK O	RDER NON-CONFO	ORMANC	E (NCI	R)			
		Description of NC		Corrective Action Section			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief En		ption 	Sign Date	& Sect	ion C	Chief Eng	QC Inspecto
							•			
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